

Date: Monday, 18/08/2008 4:03:23 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LITTER TIE DOWN ASS'Y (LOCKING) - UNDER		
Job Number	41338			Part Number	D2360		
Estimate Number	10495			Drawing Number	D2360/D2341		
P.O. Number				Project Number	N/A		
This Issue	18/08/2008	S.O. No.		Drawing Revision	D / F		
Prsht Rev.	NC			Material			
First Issue	18/08/2008	Type	MACHINED PARTS	Due Date	10/09/2008	Qty:	6
Previous Run	39455			Um:	Each		
Written By							
Checked & Approved By	JUL 08 8-18						
Comment	est rev H 07.06.12 ecn 825 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6201	"T" Extrusion
		Comment: Qty.: 1.1067 f(s)/Unit Total : 6.6402 f(s) Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion) Batch: B36793 <i>GRW 08/09/14</i> (1)
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: 12.65" Long <i>GRW 08/09/14</i> (1)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio D2341 and Dwg D2341 <i>GRW 08/09/14 20 08/02/16</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>GRW 08/09/14 20 08/02/16</i>
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>GRW 08/09/17</i>
6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Deburr and Tumble <i>GRW 08/09/16 08</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
1/17/01		~250 slot 15 low because of vise jaws and X axis origin						

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5



INSPECT WORK TO CURRENT STEP

N/A 10.08/17

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1



HAND FINISHING RESOURCE #1

(Ex)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H 08/09/17

9.0 POWDER COATING



POWDER COATING



M108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:00 pm

OVEN TEMPERATURE: 376°F

FINISH TIME: 1:30 pm

9/08-09-17 X6

10.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/9/18

(Ex) SP

11.0 D2002015



Knob

161710



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Knob

SP

12.0 D2345



Lock Channel

B35571 39474



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lock Channel

13.0 D2366



Lock Handle

B3743



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Inventory

14.0 D2367



Handle Knob

B33794



(Ex)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Inventory

8/9/18

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 D2372 Quick Release



41426



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Quick Release

16.0 D2373 Spring



(2) 26458 (4) 36922



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Spring

17.0 D2444 Pip Pin Assembly



41429



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pip Pin Assembly

18.0 AN526C1032R18 Screw



4523



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Screw

19.0 AN960JD10 Washer



104517



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer

20.0 AN960JD10L Washer



105793



SP

Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)
Washer

21.0 MS20470AD34 Rivet,Universal Head



15541



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Rivet,Universal Head

22.0 MS21042L3 Nut



Nut

15

(3)

103641

104625



6x

Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)
Nut

8/10/18

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation:

Description :

23.0 MS27039113

Screw



13719



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

SP

24.0 MS27039115

Screw



108169



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

SP

25.0 NAS679A3W

Nut



WT63



6X

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

SP

26.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



8/9/18



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2360

EP 08/09/18 (6)

27.0 QC5

INSPECT WORK TO CURRENT STEP



So 08/09/18 (6)

Comment: INSPECT WORK TO CURRENT STEP

28.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

ST188

EP 08/19/19 (6)

29.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/19 (6)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



~MF 08-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41338
Description: Litter Tie Down Bracket (Locking)	Part Number:	D2341
Inspection Dwg: D2341 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

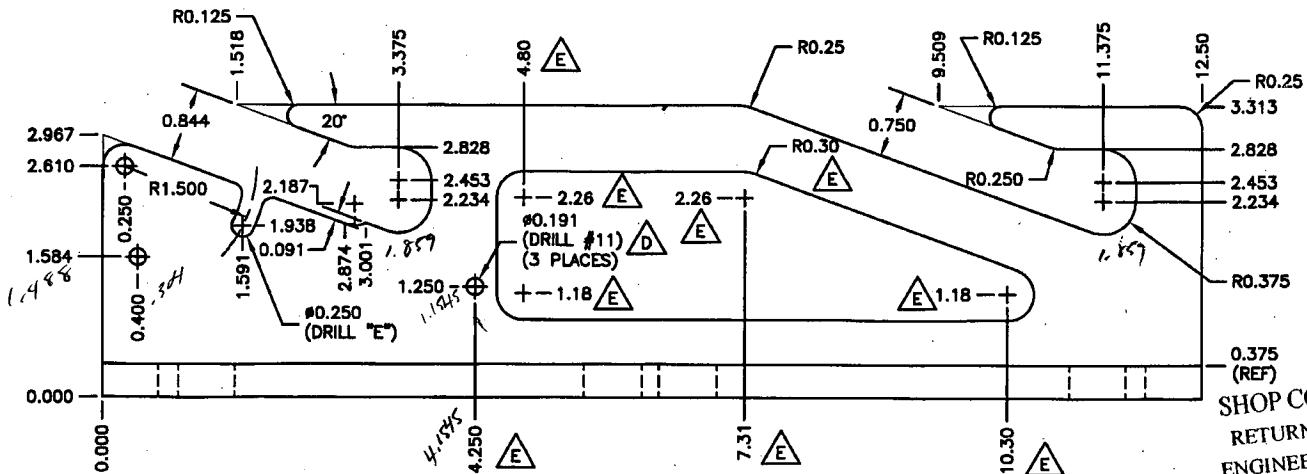
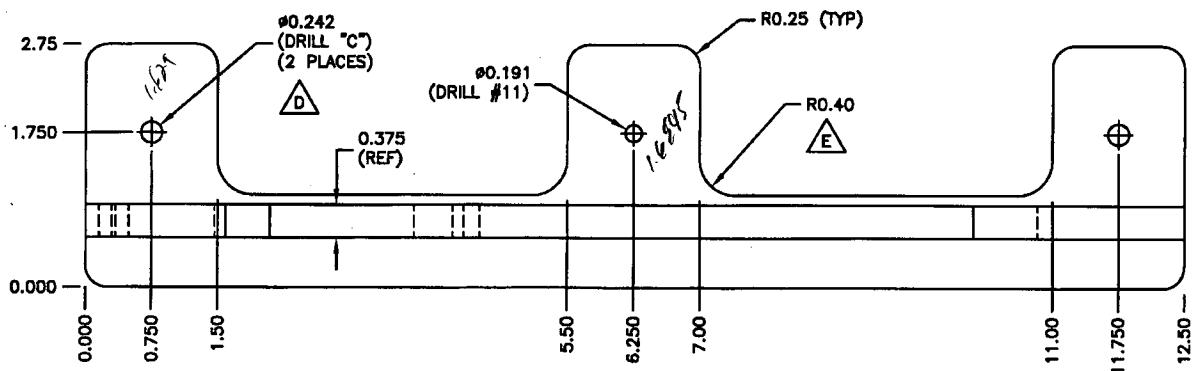
X First Article Prototype

Measured by:	<i>RQ</i>	Audited by:	<i>SP</i>	Prototype Approval:	N/A
Date:	<i>08/09/16</i>	Date:	<i>08/09/17</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	E

DART

DESIGN BW	DRAWN BY <i>JC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>MM</i>	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	



D2341 LITTER TIE DOWN BRACKET (LOCKING)

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

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WITHOUT NOTICE

RELEASED *1/3*
07-06-22 *MM*

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED SH	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

07.06.07

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT



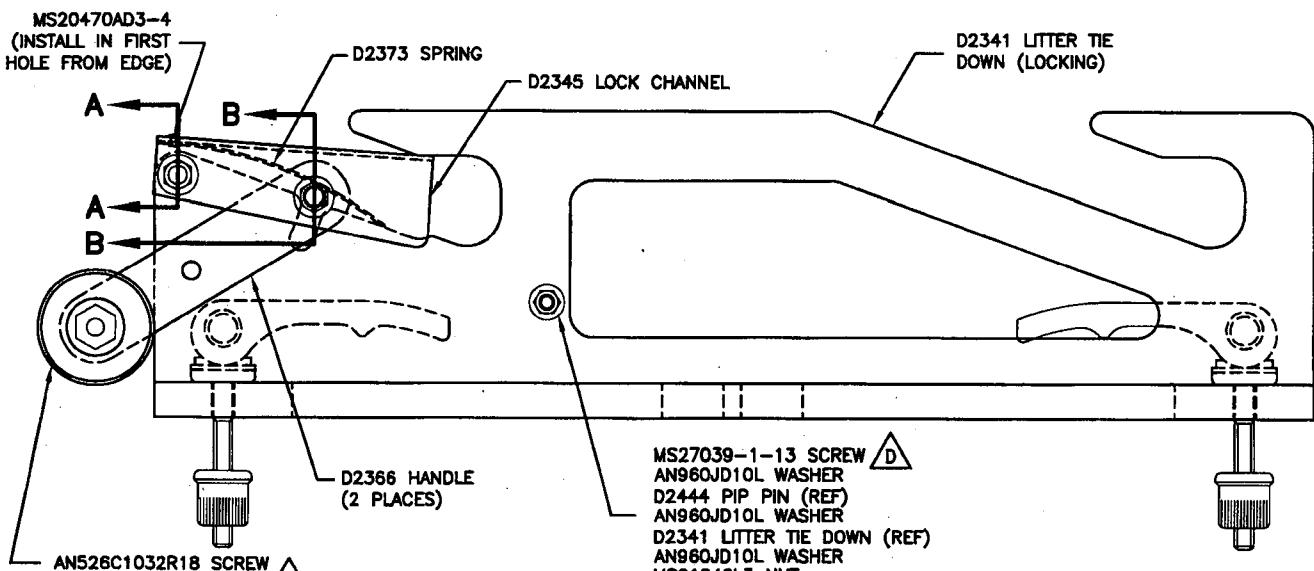
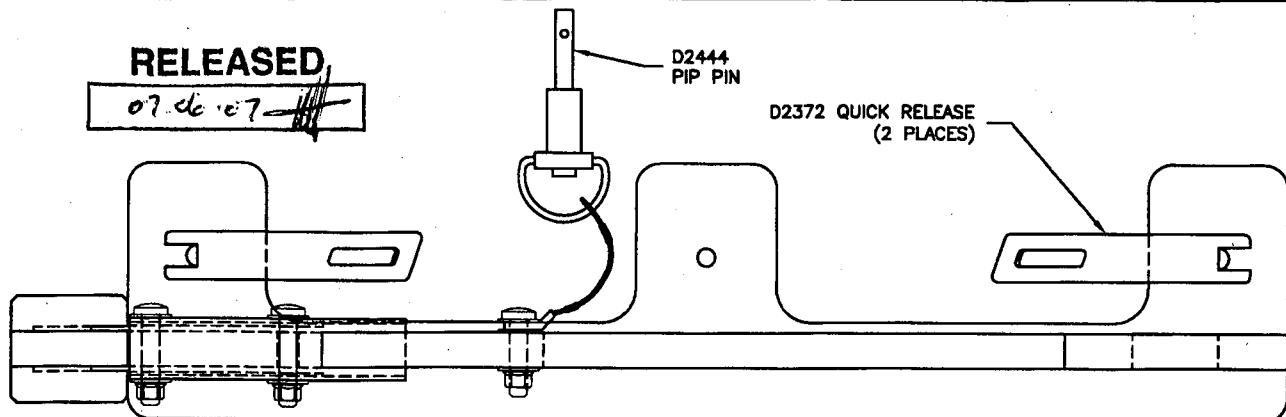
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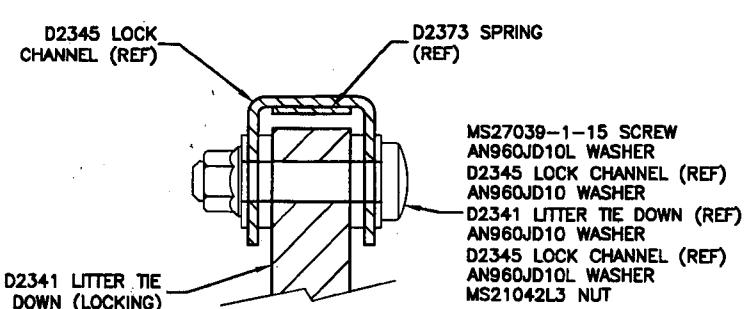
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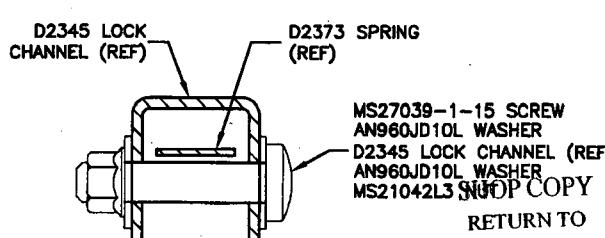
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED H	DRAWING NO. D2360
DATE 07.06.06		REV. D SHEET 2 OF 2
		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS

RELEASED07.06.07 ~~07.06.07~~

D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



SECTION A-A
(SCALE 1:1)



SECTION B-B
(SCALE 1:1)

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WORK ORDER

NO *47338*

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